

AIMJORACO™

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AUTOMATED INDUSTRIAL MACHINE, INC TOGGLE-AIRE® DIVISION

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Model 2000 PLC

Operating Instructions



General:

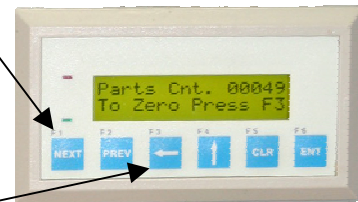
A. Batch and Grand Total counters only count in the Automatic Mode and can only be reset to zero when the Off-Stop-Run switch is in the STOP position.

B. Moving through the various screens (4) is accomplished using the buttons Marked NEXT and PREV on the Operator Interface.



Screens:

Screen 1 - Parts Count screen shows the progression of the Batch Counter as the indexer operates in the Automatic Mode. Press F3 to reset this counter to zero.



Screen 2 - Batch Count screen is used to set the quantity in a batch. When the batch count is enabled and the parts count reaches this number, the indexer will stop (Auto Mode ONLY). The Parts count must be set to zero (see above) before continuing operation.



To set the batch count, the Off-Stop-Run switch must be in the Stop position. Press ENT then CLR, cursor should now be flashing. Press the Up arrow to increase the digit, Down arrow to decrease the digit. When correct digit is displayed, press left arrow to shift the digit to the left and repeat until the desired Batch Count is displayed. Press ENT again to set Batch count.

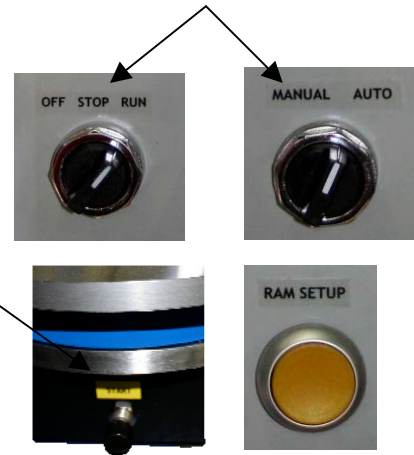


Screen 3 - Grand Total Screen displays the results of the Grand Total Counter. This count will continue to increase until it is either reset to zero [CLR] or it reaches 599,999,999 at which point it will automatically reset to zero.

Screen 4 - Batch Count Enable screen is used to enable or disable the Batch Count function. To enable batch counting press F3, to disable press F5.

Operating Modes:

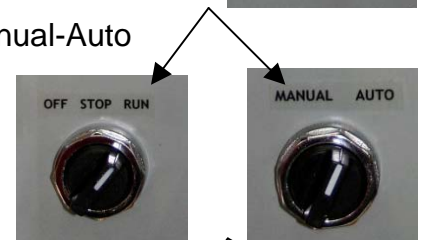
Ram Set UP - Set Off-Stop-Run switch to STOP position and Manual-Auto switch to MANUAL. Press RAM SETUP button, it should latch in and light up. Press the START button (front of press under indexing table), the ram should descend and until the RAM SETUP button is pressed again it.



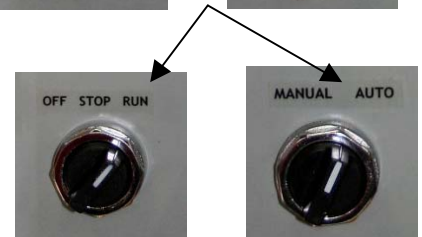
Rotary Table Only - Set Off-Stop-Run switch to STOP position and Manual-Auto switch to MANUAL. Set ROTARY TABLE ONLY toggle switch to the up position. Press the START button, the rotary table will index one position and stop, the ram will remain up. Press START to repeat.



Manual Mode - Set Off-Stop-Run switch to RUN and Manual-Auto switch to MANUAL. Press the START button, the rotary table will index one position, the ram will descend and return. Pressing the START button will repeat the sequence.



Automatic Mode - Set Off-Stop-Run switch to RUN and Manual-Auto switch to AUTO. Press the Start button, the rotary table will index one position, the ram will descend and return. This sequence will repeat until either the Off-Stop-Run switch is set to the STOP position, or the Parts Counter reaches the preset Batch Count if enabled.



Emergency Stop - If at any time the EMERGENCY STOP button is pressed or the Ram Guard switch is dislodged, the indexer will cease to operate and the compressed air will be turned off.



To Restore the System, the Off-Stop-Run switch must be set to Off, the Emergency Stop Button reset (twist) and/or the Ram Guard repositioned. Turning the Off-Stop-Run switch to Stop will restore the compressed air and the indexer is ready to run.